

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEFT ARM WELDMENT
Job Number	: 31584		
Estimate Number	: 11871		
P.O. Number	: <i>N/A</i>	Part Number	: D33549
This Issue	: 4/4/2007      S.O. No. : <i>N/A</i>	Drawing Number	: D3354 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 31304	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 4/11/2007      Qty:      3   Um:      Each
Checked & Approved By	: <i>[Signature]</i> 07.04.07		
Comment	: est. rev.A   06.01.14   new issue   EC		
	: rev B   07.03.23   rev B dewg   ec		

Job Number:



1.0	M1020TR1250W219	Seamless Round Tubing
-----	-----------------	-----------------------



Comment: Qty.: 0.2405 f(s)/Unit Total : 0.7214 f(s)

### Seamless Round Tubing

AISI 1020 1.25" OD x .219" wall

batch: m 19343

DJP 07/04/07 (3)

20	LATHE CONV.	CONVENTIONAL LATHE
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**Comment:** CONVENTIONAL LATHE

1-Turn as per dwg D3354

## 2- Debut

DJP 07/04/07 (3)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1-Drill hole, mill flat & c'sink as per dwg D3354

2- Mill angle on end as per dwg D3354


### 3- Deburrr

DJP 07/04/07 (3)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE


3  
 DSP 07/04/07 / 1.1 ✓ 07/04/07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: P Date: 07/04/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:57:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 31584

Part Number: D33549

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 07.04.07

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 7/4/10 (3)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

SD 07.04.11

Job Completion



U 07.04.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

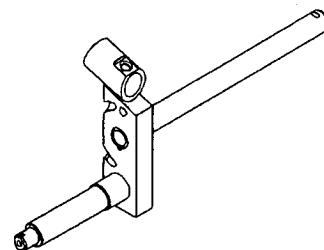
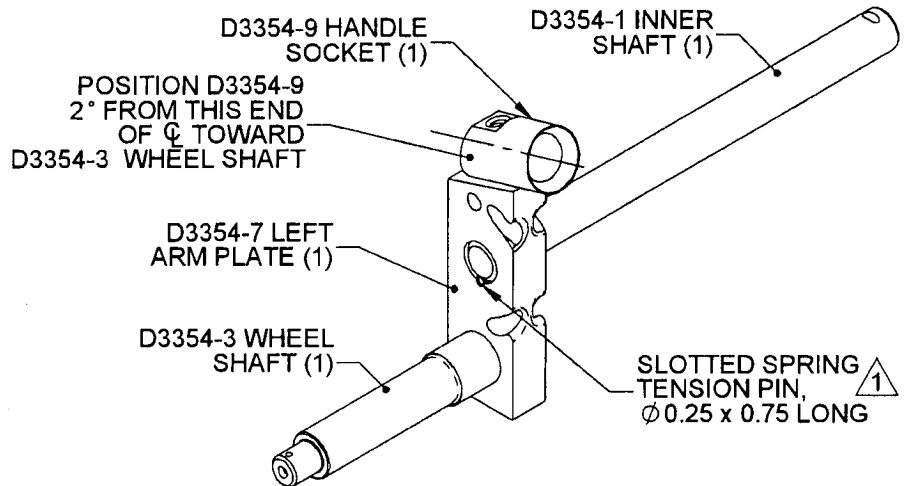
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



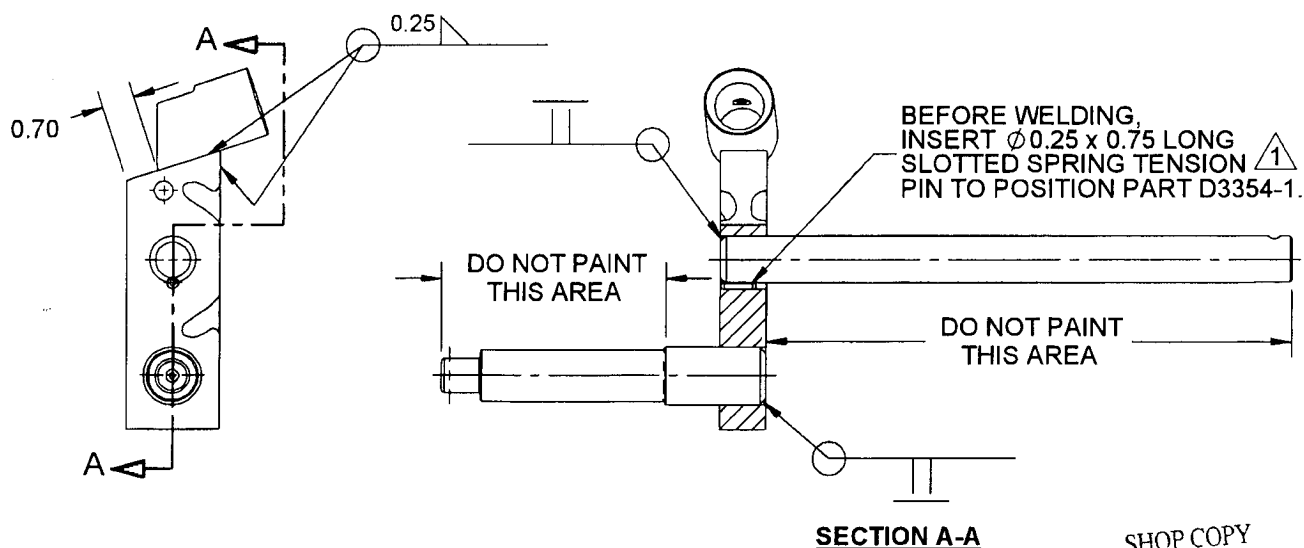
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CHECKED <i>llh</i>	APPROVED <i>llh</i>	DRAWING NO. LEFT ARM WELDMENT	REV. B SHEET 1 OF 7
DATE 07.02.02	TITLE D3354		SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

RELEASED  
07.02.02



**D3354-042 MIRROR  
ARM WELDMENT**

**D3354-041 LEFT ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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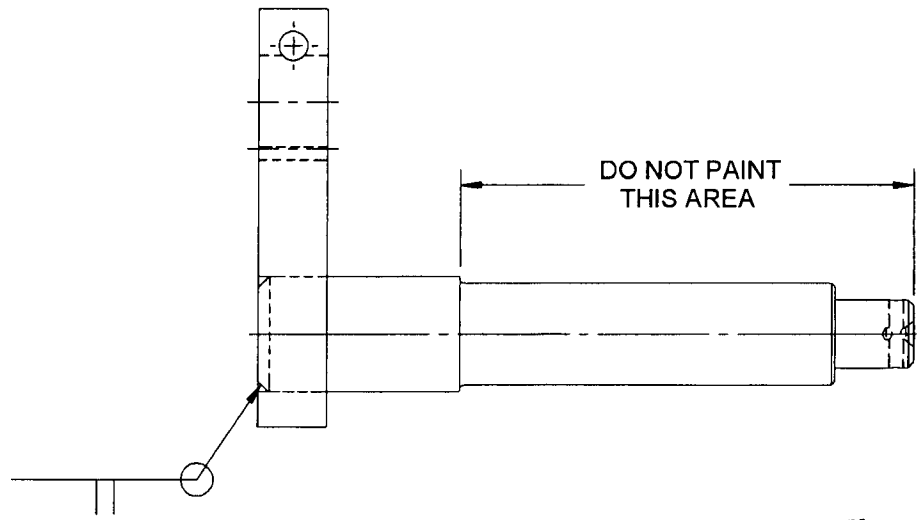
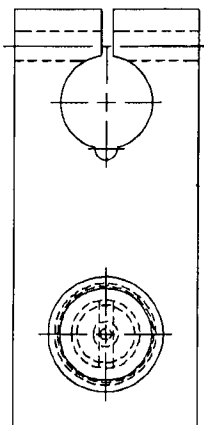
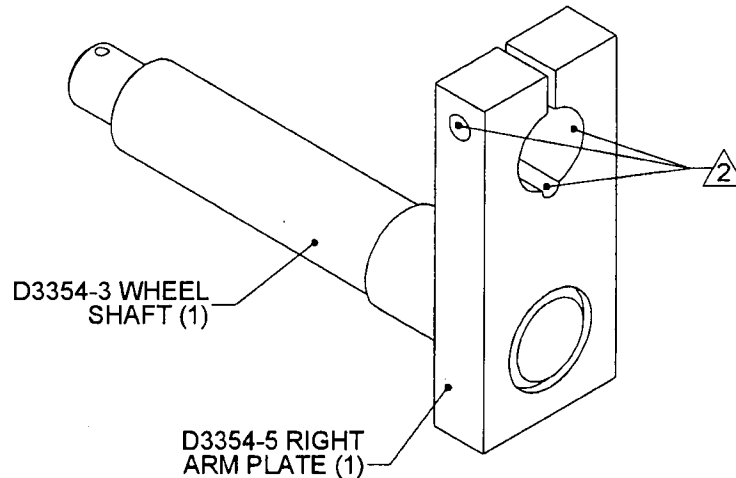
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

**RELEASED**  
*[Stamp]* 07.02.02**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

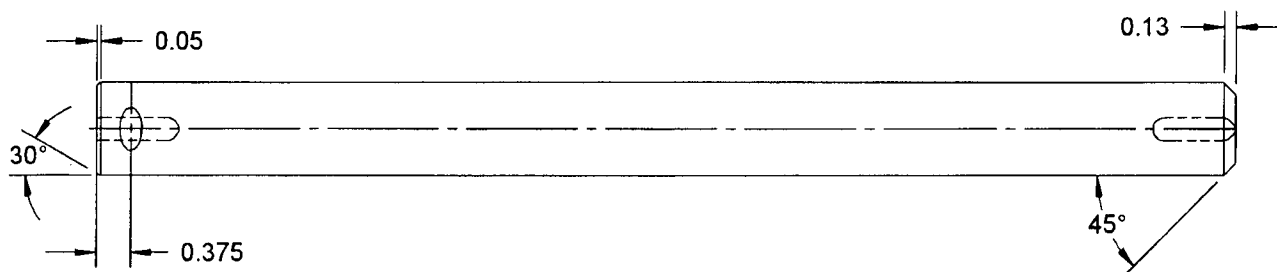
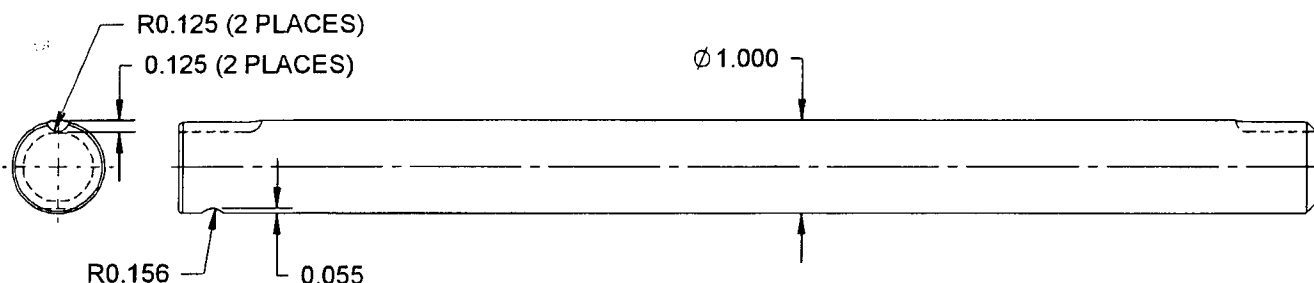
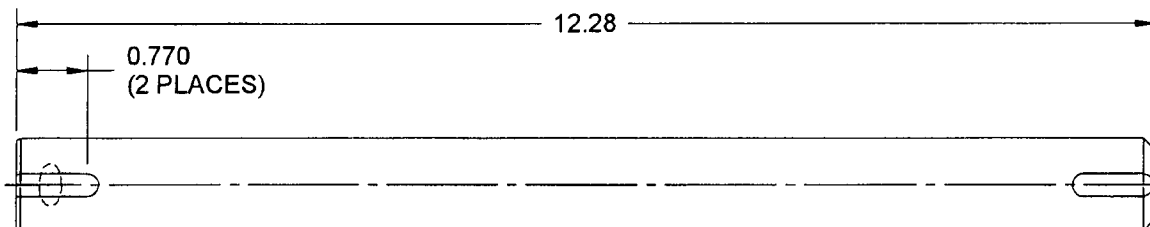
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*31584*

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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

**RELEASED**  
*[Signature]* 07.02.02**D3354-1 INNER SHAFT**

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**NOTES:**

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OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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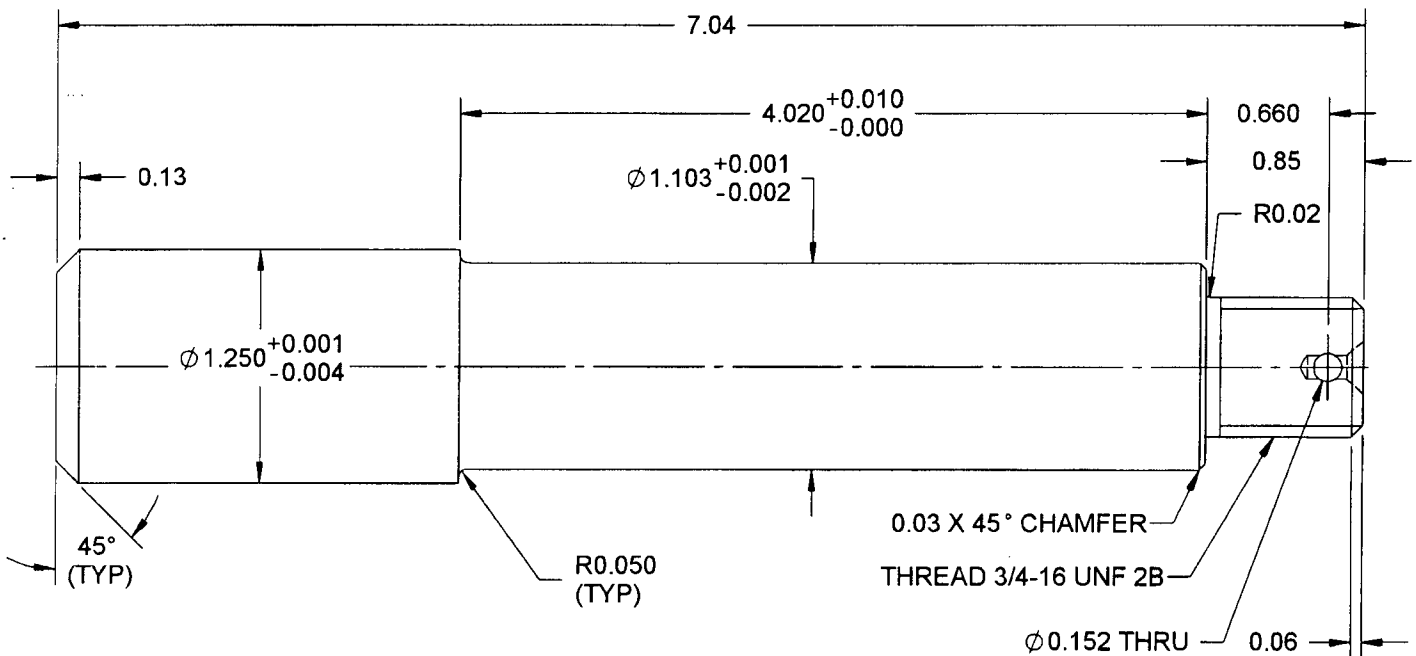
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

**RELEASED**  
*07.02.02***D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

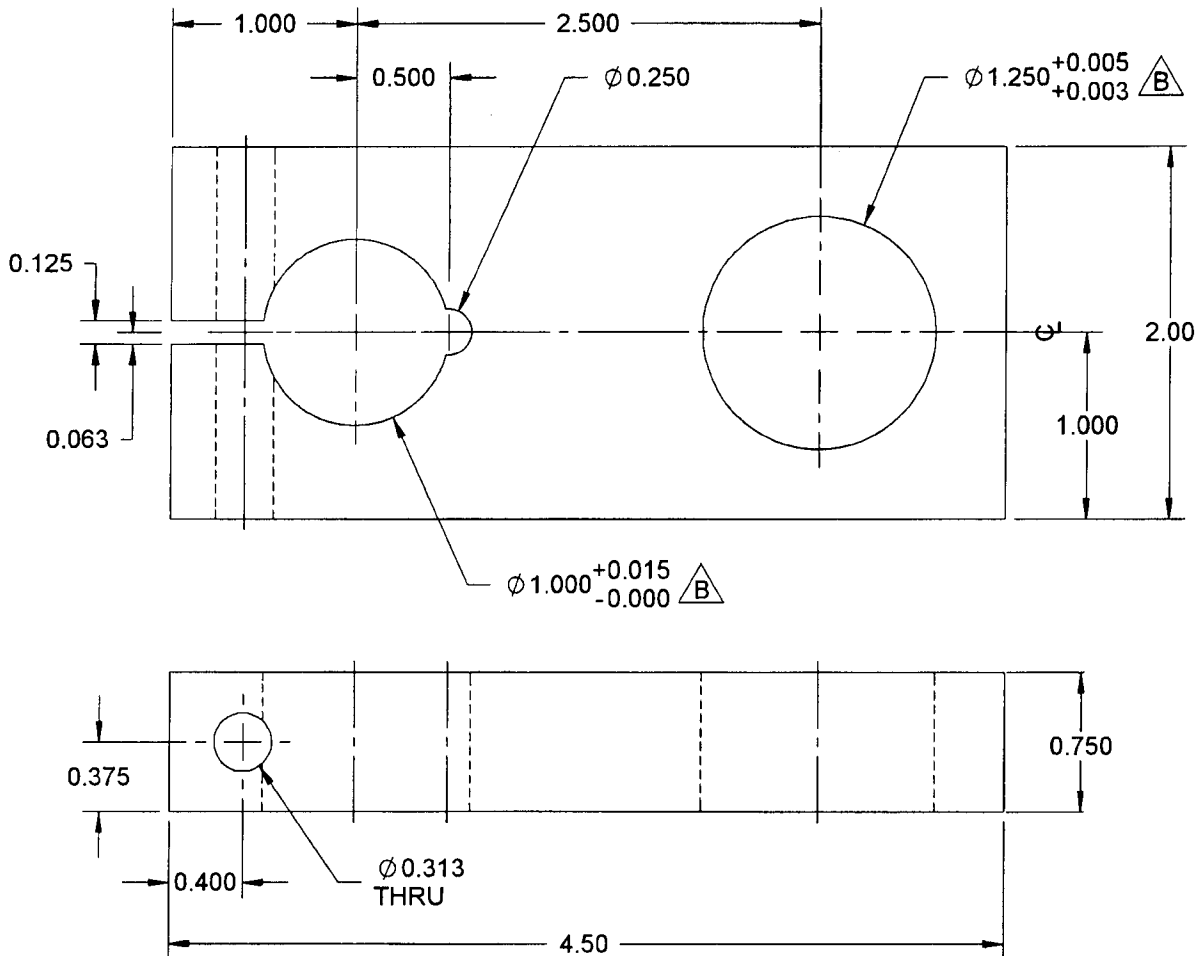
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*wh 07.02.02***D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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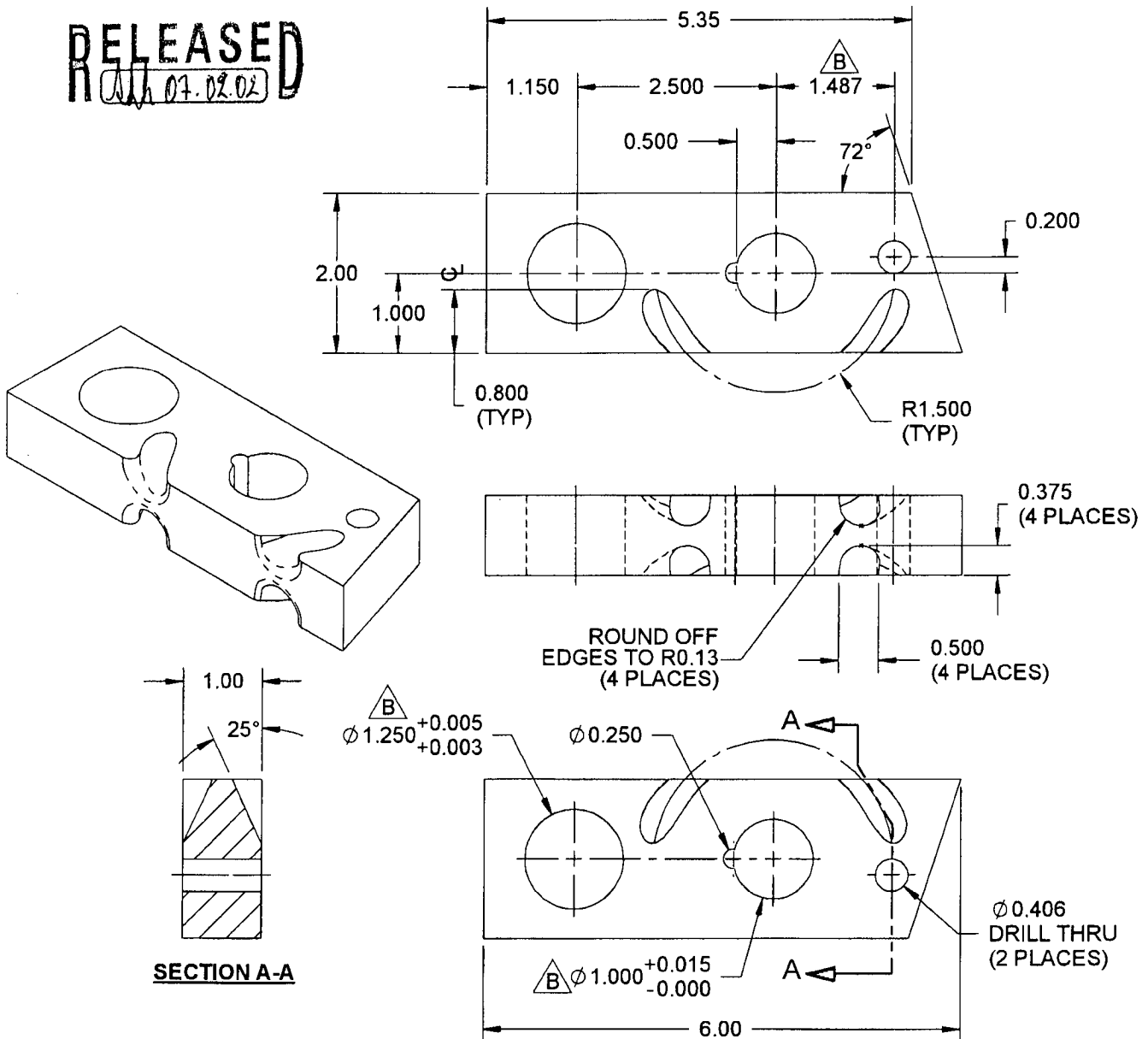
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

RELEASED  
*07.02.02*



### D3354-7 LEFT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

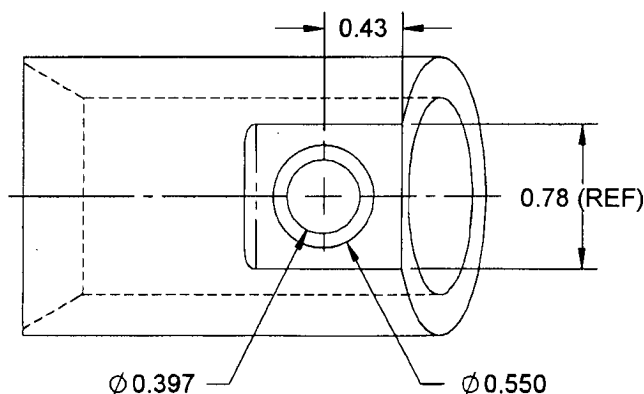
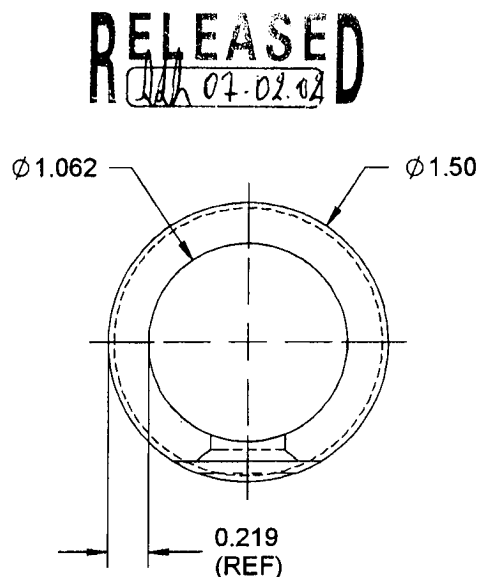
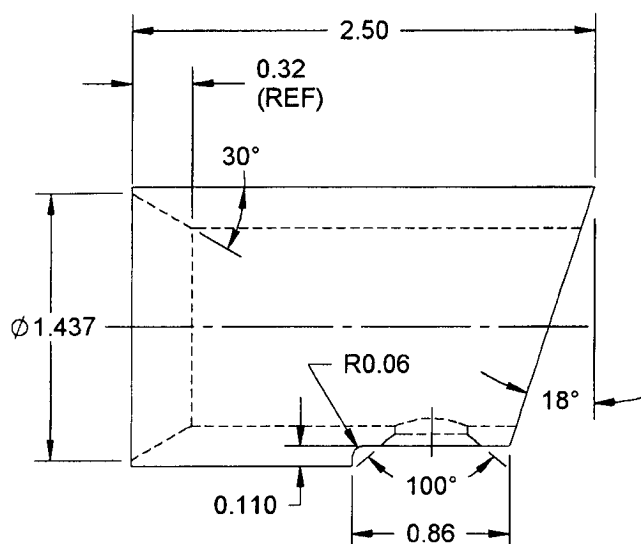
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SHEET 7 OF 7 SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DART AEROSPACE LTD		Work Order: 31584
Description: Left ARM Weldment		Part Number: D33549
Inspection Dwg:	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	±0.030	1.503	✓			
1.062	±0.010	1.0600	✓			
0.219(REF)	±0.010	0.220	✓			
2.50	±0.030	2.500	✓			
0.32(REF)	±0.030	0.32	✓			
1.437	±0.010	1.440	✓			
30°	± 1/2°	30°	✓			
0.86	±0.030	0.862	✓			
0.110	±0.010	0.112	✓			
R0.06	±0.030	0.06	✓			
0.78(REF)	±0.030	0.800	✓			
<del>0.43</del> 0.43	±0.030	0.429	✓			
0.397	+0.006 -0.001	0.399	✓			
0.550	±0.010	0.560	✓			
100°	± 1/2°	100°	✓			
18°	± 1/2°	18°	✓			

Measured by: DSP	Audited by: J.B	Prototype Approval:
Date: 07/04/07	Date: 07/04/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	